

Date: Wednesday, 07/05/2008 11:55:55 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	DUAL HIGH BACK SEAT
Job Number :	39101		
Estimate Number :	10871		
P.O. Number :		Part Number :	D350689011
This Issue :	07/05/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	N/A
First Issue :	//	Project Number :	N/A
Previous Run :	37808	Drawing Revision :	N/A
	Type :	Material :	N/A
	LARGE FAB ASSY	Due Date :	30/05/2008
Written By :		Qty:	1 Um: Each
Checked & Approved By :	JLD 08.5.07		
Comment :	Est Rev:B 03.05.09 Reformat; Modify Step 1 KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D350-689-011 CHG002

JLD
08.5.08

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0	D30181	Seat Cushion
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D3018-1 Seat Cushion

B24599

JLD 08.5.08 (X)

4.0	D30191	Seat Cushion
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D3019-1 Back Cushion

24600

JLD 08.5.08 (X)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 07/05/2008 11:55:55 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DUAL HIGH BACK SEAT

Job Number: 39101

Part Number: D350689011

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D350689013

Floor Provisions



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D350-689-013 Floor Provisions Kit

B38697

AS 08/06/12 (X)

6.0

D350689041

Dual High Back Seat Ass'y



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D350-689-041 Dual Seat Assy

B37805

New Batch

AS 08/06/12 (X)

7.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

08/06/13 (X)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-689-011

Location:

PPP Rev:

Rev E

8/6/13

SP

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/06/16 (X)

Job Completion



u 08/06/16

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4. WEIGHT AND BALANCE

The following weight and balance information is for the Dart Dual High Back Seat Installation. The weight and balance of the parts that are removed from the aircraft to perform this installation are the responsibility of the installer.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-689-011	27.0 lb	-18.2 in	-491 in-lb	60.7 in	1639 in-lb
Dual High Back Seat Installation	12.2 kg	-0.46 m	-5.6 m-kg	1.54 m	18.8 m-kg
D350-689-013	2.0 lb	-18.2 in	-36 in-lb	60.7 in	121 in-lb
Floor Provisions Kit	0.9 kg	-0.46 m	-0.4 m-kg	1.54 m	1.4 m-kg

5. PARTS LIST

Qty		Part Number	Description
X		D350-689-011	DUAL HIGH BACK SEAT INSTALLATION, LH
1	X	D350-689-013	FLOOR PROVISIONS KIT
1		X D350-689-041	DUAL HIGH BACK SEAT ASSEMBLY
	2	D3016-041	SEAT FRAME ASSEMBLY
	1	D3017-041	BACK FRAME ASSEMBLY
1		D3018-1	SEAT CUSHION
1		D3019-1	BACK CUSHION
	1	D3021-041	TUBE ASSEMBLY
	1	D3022-1	SEAT PAN
	1	D3023-1	BACK PANEL
	3	D3024-1	SPACER
1		D3025-1	BEAM
1		D3026-1	CHANNEL
1		D3027-1	CLIP
1		D3027-3	CLIP
1		D3027-5	CLIP
4		D3027-7	CLIP
	4	D3028-1	STUD
	2	D3029-1	SPRING
	2	D3030-1	LOCK
	2	D3031-1	LOOP
1		D3032-1	SPACER
1		D3033-1	SEAT TRACK
1		D3033-3	SEAT TRACK
6	23	AN960JD10L	WASHER
	3	AN3-12A	BOLT
16		MS20426AD3-6	RIVET
17		MS20426AD4-6	RIVET
18		MS20470AD4-5	RIVET
2		MS20470AD4-6	RIVET
30		MS20470AD5-6	RIVET
	46	MS20600AD4W2	RIVET
8		MS21059L3	NUTPLATE
6		MS27039-1-10	SCREW
	4	MS27039-1-17	SCREW
	12	MS27039-1-19	SCREW
	4	MS24693-S272	SCREW
2		MS24693-S273	SCREW
	23	MS21042L3	NUT (OR MS21042-3)

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Revision: **A**
Date: 01.05.30